PATENT COOPERATION SATY

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NOTIFICATION OF ELECTION

(PCT Rule 61.2)

From the INTERNATIONAL BUREAU

To:

Assistant Commissioner for Patents United States Patent and Trademark Office Box PCT

Washington, D.C.20231 ETATS-UNIS D'AMERIQUE

Date of mailing (day/month/year)
27 September 2000 (27.09.00)

in its capacity as elected Office

International application No. PCT/GB00/00286

Applicant's or agent's file reference XA1003

International filing date (day/month/year) 02 February 2000 (02.02.00) Priority date (day/month/year) 08 February 1999 (08.02.99)

Applicant

GRAY, lan, Lindsay

1.	The designated Office is hereby notified of its election made:
	X in the demand filed with the International Preliminary Examining Authority on:
	19 August 2000 (19.08.00)
	in a notice effecting later election filed with the International Bureau on:
	The stantism V
2.	The election X was was not
	made before the expiration of 19 months from the priority date or, where Rule 32 applies, within the time limit under Rule 32.2(b).

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GB

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(72) Inventor; and

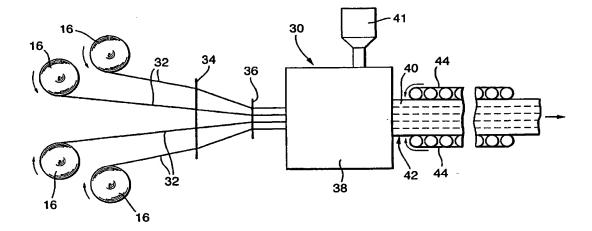
- (75) Inventor/Applicant (for US only): GRAY, Ian, Lindsay [GB/GB]; BAE Systems, Building 07C, New Filton House, Filton, Bristol, Avon BS99 7AR (GB).
- (74) Agent: EDIS, Ronald, Malcolm; BAE Systems, Group IP Dept., Lancaster House, P.O. Box 87, Farnborough Aerospace Centre, Farnborough, Hampshire GU14 6YU (GB).

(81) Designated States: AE, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CR, CU, CZ, DE, DK, DM, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, TZ, UA, UG, US, UZ, VN, YU, ZA, ZW, ARIPO patent (GH, GM, KE, LS, MW, SD, SL, SZ, TZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GW, ML, MR, NE, SN, TD, TG).

Published

With international search report.

(54) Title: FIBRE REINFORCED COMPOSITES AND METHOD OF MAKING SAME



(57) Abstract

A method is disclosed for producing a fibre reinforced composite by pultrusion having variable strength characteristics along its length including the steps of drawing through a pultrusion die (38) a series of reinforcing fibres (32) to form a pultruded fibre composite product. The method is characterided by incorporating in the reinforcing fibres (14) prior to the pultrusion step additional fibres (20) to form modified fibres (32) having a characteristic such as tenacity or modulus different from that of the first said reinforcing fibres (14) in order to wary the strength characteristics of the final composite (42) substantially without altering the cross-sectional area thereof. A curable or settable plastics material (40) is applied around the fibres during the pultrusion step and which is cured, part-cured or allowed to set to form the finished composite (42).

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FIBRE REINFORCED COMPOSITES AND METHOD OF MAKING SAME

This invention relates to fibre reinforced composites, in particular those used in high strength applications such as aircraft structures.

It is known to manufacture by pultrusion, composite structural members for use as skin stringers for aircraft wing and fuselage skins, for example. Such pultruded members are currently manufactured by drawing reinforcing fibres, such as carbon fibres, through a die, applying liquid plastics matrix material to the fibres, and curing or setting the whole to form a fibre reinforced composite structural member of the required cross-sectional shape and of indefinite length.

There exists a requirement to provide structural members such as aircraft wing or fuselage skin stringers with strength characteristics which vary along their length. It is currently proposed to provide such a member with variable cross-section in order to achieve the variation in strength required. Unfortunately such changes in cross-sectional shape for pultruded members are not easy to achieve. Currently variable shape pultrusion dies are being investigated with a view to allowing changes in cross-sectional shape of the structural member along its length. It will be appreciated that such variable cross-section dies will be somewhat complex and possibly difficult to produce. In addition their reliability and/or longevity may be limited.

According to the present invention there is provided a method of producing a fibre reinforced composite by pultrusion having strength characteristics which vary along the length of the composite, the method including the steps of drawing through a pultrusion die a series of reinforcing fibres to form a pultruded fibre composite product characterised by incorporating in the reinforcing fibres prior to the pultrusion step additional fibres, which may have a characteristic such as tenacity or modulus different from that of the said reinforcing fibres, in order to vary the strength characteristics of the final product along the said length substantially without altering

the cross-sectional area thereof, a curable or settable plastics matrix material being applied around the fibres and solidified by being cured or allowed to set to form the finished composite.

By "tenacity" is meant tensile strength per unit area of fibre. In this way a higher tenacity fibre may have a reduced cross sectional area compared with a lower tenacity fibre. By "modulus" is meant Young's modulus for the fibre concerned.

Preferably, the additional fibres are either spliced between discrete lengths of the reinforcing fibres, or interlaced or otherwise distributed amongst continuous said reinforcing fibres.

The fibres may be pre-impregnated with the plastics material before being drawn through the protrusion die. If the fibres are not pre-impregnated then a plastics material may be introduced amongst the fibres as they are drawn through the die. Where the plastics material is curable, the pultrusion die may be heated to effect curing or part curing of the plastics material.

The fibres may be in the form of individual strands, or may form woven and/or non-woven webs.

A method in accordance with the invention will now be described by way of example, and with reference to the accompanying drawings in which:

Figure 1 is a diagrammatic view of an apparatus for splicing fibres for use in a method in accordance with the invention;

Figure 2a is an alternative enlarged diagrammatic view of box A in Figure 1;

Figure 2b is an enlarged diagrammatic view of box A in Figure 1; and

Figure 3 is a diagrammatic view of a pultrusion apparatus for producing a fibre reinforced composite in accordance with the invention.

Figure 1 shows an apparatus for splicing fibres and comprises a substantially horizontal work bench 10, a source roll 12 of reinforcing fibres 14 and a product receiving roll 16.

Reinforcing fibres 14 are drawn off the source roll 12, across the work bench 10 and wound onto the product receiving roll 16.

Additional fibres 20 are provided which can either be spliced between lengths 26, 28 of the reinforcing fibres (Figure 2a) to provide an area 18 having a characteristic such as tenacity or modulus different from that of the fibres 14, or can be interlaced or otherwise distributed amongst the reinforcing fibres 14 (Figure 2b).

When the additional fibres 20, are spliced into the reinforcing fibres 14 as shown in Figure 2a, the ends of the fibres may either be knotted together or air blown so that the fibres become matted together to form a joint 22. It should be noted that the joint 22 so formed primarily allows continuity of the pultrusion process.

It should be further noted that it is preferable for the introduction of a change in fibre type to be phased over the predetermined area or areas 18. By phasing the introduction of the additional fibres, stress on individual joints between the fibres is spread over a greater area thus minimising stress concentration.

In Figure 2a it will be noted that the phased introduction leads to the additional fibres 20 meeting the reinforcing fibres 14 on an oblique plane 24 although it will be understood that other suitable phased introduction, e.g. a zig-zag, could be used.

The product receiving roll 16 is then transferred to a pultruding apparatus 30 as shown in Figure 3. The pultruding apparatus 30 includes supports (not shown) for a number of product receiving rolls 16. In the present example, four rolls 16 are carried by the supports. The modified fibres, indicated at 32, are drawn from the rolls 16 and aligned through guide vanes 34 and 36 so as to position them in a predetermined pattern.

WO 00/47397 PCT/GB00/00286

The modified fibres 32 are then pulled through a pultrusion die 38. Resin 40 from a supply 41 is injected amongst the fibres 32 as they are drawn through the die 38 to produce a fibre reinforced composite 42 of substantially constant cross-sectional area. The fibre reinforced composite 42 is part drawn out through the die 38 by reciprocating caterpillar pullers 44.

Where the additional fibres 20 are distributed amongst the reinforcing fibres 14 as in Figure 2b there is a reduction in the ratio of fibre 32 to resin 40 content of the final composite 42 compared to the composition in which the fibres are spliced as shown in Figure 2a.

The fibres 32 may also be pre-impregnated with resin before drawing them through the pultrusion die 38. That may alleviate, or avoid altogether, the need to inject resin 40 amongst the fibres 32 as they are pulled through the die 38.

The fibres 32 may be in the form of a fabric, which may be woven and/or non-woven.

If the resin is curable, the pultrusion die 38 may be heated to effect curing or part curing of the resin.

In the present example, the plastics matrix material used is a resin, although it may also be any adhesive/matrix system.

The length of the predetermined area 18 along the fibres 14 can be selected as required.

The above methods enable the production of a fibre reinforced composite having variable strength characteristics along its length without alteration of the cross-sectional area of the pultruded composite.

WO 00/47397 5 PCT/GB00/00286

Claims

- 1. A method of producing a fibre reinforced composite by pultrusion having variable strength characteristics along its length including the steps of drawing through a pultrusion die a series of reinforcing fibres to form a pultruded fibre composite product characterised by incorporating in the reinforcing fibres prior to the pultrusion step additional fibres in order to vary the strength characteristics of the final product substantially without altering the cross-sectional area thereof, a plastics matrix material being applied around the fibres and allowed to solidify to form the finished composite.
- 2. A method according to claim 1 in which the additional fibres have a characteristic different from that of the said reinforcing fibres.
- 3. A method according to claim 2 in which the said characteristic is selected from the group fibre tenacity and fibre modulus.
- 4. A method according to claim 1, 2 or 3 in which the additional fibres are spliced between discrete lengths of the reinforcing fibres.
- 5. A method according to claim 1, 2 or 3 in which the additional fibres are interlaced amongst continuous said reinforcing fibres.
- 6. A method according to any of claims 1 to 5 in which the plastics matrix material is applied to the fibres, within the die.
- 7. A method according to any of claims 1 to 5 in which the fibres are preimpregnated with a plastics matrix material before being drawn through the die.
- 8. A method according to any preceding claim in which the fibres are in the form of a woven web.

- 9. A method according to any one of claims 1 7 in which the fibres are in the form of a non-woven web.
- 10. A composite structural member produced according to the method of any preceding claim.
- 11. A composite structural member according to claim 10 comprising an aircraft skin stringer.
- 12. An aircraft aerofoil incorporating a composite structural member according to claim 10 or 11.
- 13. An aircraft containing a composite produced according to the method of any of claims 1 to 9.

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Fig.1.

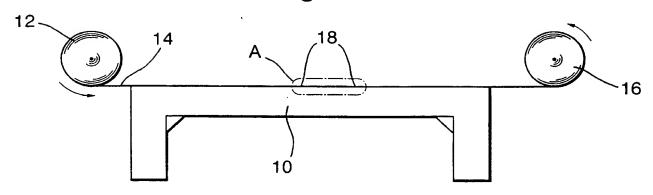


Fig.2a.

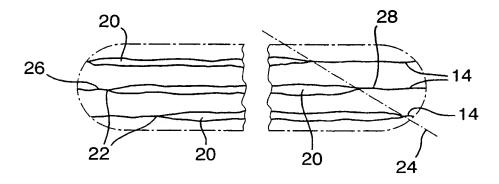
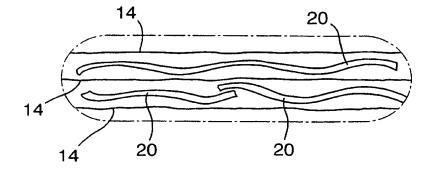
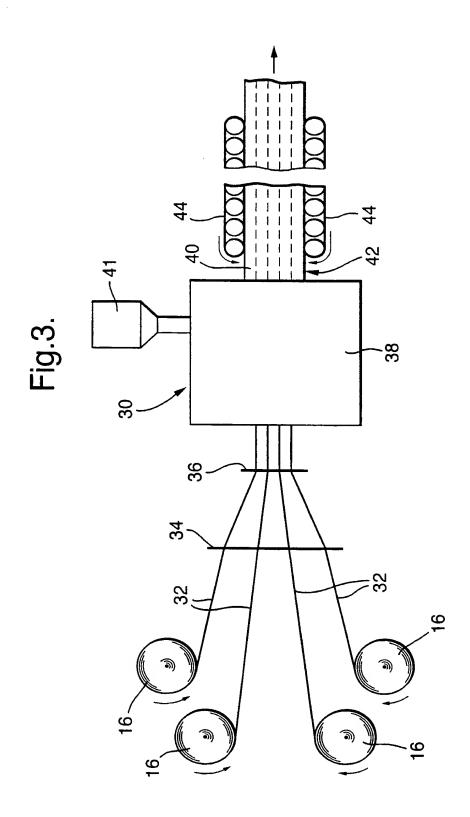


Fig.2b.



SUBSTITUTE SHEET (RULE 26)



inte onal Application No PCT/GB 00/00286

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IPC 7	FICATION OF SUBJECT MATTER B29C70/52		
	o International Patent Classification (IPC) or to both national classification	ation and IPC	
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Minimum de IPC 7	ocumentation searched (classification system followed by classification B29C	on symbols)	
Documenta	tion searched other than minimum documentation to the extent that so	uch documents are included in the fields se	arched
Electronic o	lata base consulted during the international search (name of data bas	se and, where practical, search terms used)
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	ENTS CONSIDERED TO BE RELEVANT		
Category *	Citation of document, with indication, where appropriate, of the rele	evant passages	Relevant to claim No.
X	US 5 439 215 A (RATCHFORD DAVID) 8 August 1995 (1995-08-08) column 4, line 33 - line 36		1,6,10
A	US 4 605 254 A (CARMIEN JOSEPH A) 12 August 1986 (1986-08-12) column 5, line 56 - line 59)	1-13
Furt	her documents are listed in the continuation of box C.	χ Patent family members are listed	In annex.
"A" docum consid "E" earlier filling ("L" docume	etegories of cited documents: ent defining the general state of the art which is not dered to be of particular relevance document but published on or after the international date ent which may throw doubts on priority claim(s) or its cited to establish the publication date of another	T later document published after the inte or priority date and not in conflict with cited to understand the principle or the invention "X" document of particular relevance; the cannot be considered novel or cannot involve an inventive step when the do	the application but sory underlying the staimed invention be considered to current is taken alone
citatio "O" docum other "P" docum	on or other special reason (as specified) sent referring to an oral disclosure, use, exhibition or means ent published prior to the international filing date but	"Y" document of particular relevance; the or cannot be considered to Involve an in document is combined with one or mo ments, such combination being obvior in the art.	ventive step when the ore other such docu— us to a person skilled
	han the priority date claimed actual completion of the international search	*&" document member of the same patent Date of mailing of the international sec	
·	3 May 2000	16/05/2000	
Name and	mailing address of the ISA	Authorized officer	
	European Patent Office, P.B. 5818 Patentlaan 2 NL – 2280 HV Rijswijk Tel. (+31–70) 340–2040, Tx. 31 651 epo ni, Fax; (+31–70) 340–3016	Van Wallene, A	

INTE

TIONAL SEARCH REPORT

adormation on patent family members

Inter mail Application No PCT/GB 00/00286

Patent document cited in search report		Publication date		atent family nember(s)	Publication date
US 5439215	Α	08-08-1995	CA	2132567 A	25-07-1995
US 4605254	Α	12-08-1986	US	4570988 A	18-02-1986



PATENT COOPERATION TREA

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INTERNATIONAL PRELIMINARY EXAMINATION REPORT

INTERNATION	TENT COOPERATION	TREAT REC'D 1 1 MAY 2001
VR.	PCT	WIPO PCT
INTERNATION	IAL PRELIMINARY EXA	MINATION REPORT
,	(PCT Article 36 and Rul	e 70)
Applicant's or agent's file reference XA1003	FOR CURTUER ACTION	Notification of Transmittal of International minary Examination Report (Form PCT/IPEA/416)
International application No. PCT/GB00/00286	International filing date (day/month/year) 02/02/2000	Priority date (day/month/year) 08/02/1999
International Patent Classification (IPC) or nat B29C70/52	Lional classification and IPC	
Applicant BRITISH AEROSPACE PUBLIC LIM	IITED COMPANY et al.] BAE	SYSTEMS PLC
This international preliminary examinand is transmitted to the applicant and the applicant are sense.		s International Preliminary Examining Authority
	•	
2. This REPORT consists of a total of	5 sheets, including this cover sheet.	
		ription, claims and/or drawings which have
	is for this report and/or sheets containing for the Administrative Instructions und	ng rectifications made before this Authority der the PCT).
These annexes consist of a total of	4 sheets	
These differences consist of a total of	4 010000.	
This report contains indications relat	ting to the following items:	
_		
I ⊠ Basis of the report II □ Priority		
	pinion with regard to novelty, inventive	step and industrial applicability
IV	n	
V A Reasoned statement un citations and explanation	nder Article 35(2) with regard to novelty ns suporting such statement	, inventive step or industrial applicability;
VI Certain documents cite		
VII Certain defects in the in	ternational application	
VIII ⊠ Certain observations on	the international application	
Date of submission of the demand	Date of completi	on of this report
19/08/2000	09.05.2001	
Name and mailing address of the international	Authorized office	er (##SOE3 MIGN)
preliminary examining authority: European Patent Office		11 m
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INTERNATIONAL PRELIMINARY EXAMINATION REPORT

International application No. PCT/GB00/00286

I. Bas	is o	f th	r	р	rt
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	2-4		as originally filed			
	1,1	a	as received on	17/04/2001	with letter of	11/04/2001
	Cla	ims, No.:				
	1-1	1	as received on	12/02/2001	with letter of	07/02/2001
	Dra	wings, sheets:				
	1/2,	,2/2	as originally filed			
2.			guage, all the elements marked international application was file			
	The	ese elements were a	available or furnished to this Au	thority in the fo	ollowing language: ,	which is:
		the language of a	translation furnished for the pur	rposes of the i	nternational search (u	nder Rule 23.1(b)).
		the language of pu	ublication of the international ap	plication (und	er Rule 48.3(b)).	
		the language of a 55.2 and/or 55.3).	translation furnished for the pur	rposes of inter	national preliminary e	xamination (under Rule
3.			cleotide and/or amino acid sec ry examination was carried out	•		• •
		contained in the in	nternational application in writter	n form.		
		filed together with	the international application in	computer read	able form.	
		furnished subsequ	ently to this Authority in written	form.		
		furnished subsequ	ently to this Authority in compu	ter readable fo	orm.	
			t the subsequently furnished wi pplication as filed has been furr		e listing does not go b	eyond the disclosure in
		The statement tha listing has been fu	t the information recorded in co rnished.	mputer readal	ole form is identical to	the written sequence
4	The	amendments have	resulted in the cancellation of			

1. With regard to the elements of the international application (Replacement sheets which have been furnished to



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INTERNATIONAL PRELIMINARY EXAMINATION REPORT

International application No. PCT/GB00/00286

		the description,	pages:	
	\boxtimes	the claims,	Nos.:	12,13
		the drawings,	sheets:	
5.				f (some of) the amendments had not been made, since they have been as filed (Rule 70.2(c)):
		(Any replacement she report.)	eet containing su	uch amendments must be referred to under item 1 and annexed to this
6.	Add	itional observations, if	necessary:	

- V. Reasoned statement under Article 35(2) with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement
- 1. Statement

Novelty (N)

Yes:

Claims 1-11

No:

Claims

Inventive step (IS)

Yes: Claims 1-11

No: Claims

Industrial applicability (IA)

.

Yes: Claims 1-11 No: Claims

No. Olam

2. Citations and explanations see separate sheet

VII. Certain defects in the international application

The following defects in the form or contents of the international application have been noted: s e separate sheet

VIII. Certain observations on the international application

The following observations on the clarity of the claims, description, and drawings or on the question whether the claims are fully supported by the description, are made:

s e separate sheet

International application No. PCT/GB00/00286

EXAMINATION REPORT - SEPARATE SHEET

to point V

Claim 1

Document D1 = US-A5 439 215 discloses a method of producing fibre reinforced composite by pultrusion having variable strength along its length including drawing through a pultrusion die a series of reinforcing fibres to form a pultruded fibre composite product (see figures 6 - 9 and columns 3 and 4 of D1).

Neither D1 nor the other documents of the search report disclose that prior to the putrusion step additional fibres having different characteristic should be added.

Furthermore, a person skilled in the art does not get any hint to modify the known method in the manner claimed.

Thus, the subject-matter of claim 1 is new and industrially applicable and it involves an inventive step and the claim itself meets the requirements of Article 33 PCT

Claims 2 - 8

These dependent claims disclose preferred embodiments of the method claimed.

Claim 9 and 11

These claims concern to products directly obtainable by the method claimed. These products are new and inventive, since they comprise additional fibres having different characteristic. This circumstance is not known in the prior art.

Thus, the subject-matter of claim 9 and 11 is new and industrially applicable and it involves an inventive step and the claims themselves meet the requirements of Article 33 PCT.

Claim 10

This dependent claim discloses preferred embodiments of the product claimed.



t point VII

- 1 Independent claims have not been filed in the two-part form in accordance with Rule 6.3(b) PCT, with those features known in combination from the prior art (D1) being placed in a preamble (Rule 6.3(b)(i) PCT) and with the remaining features being included in a characterising part (Rule 6.3(b)(ii) PCT).
- 2 The features of the claims are not provided with reference signs placed in parentheses (Rule 6.2(b) PCT).

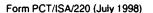
To point VIII

Although claims 1, 9 and 11 have been drafted as separate independent claims, they appear to relate effectively to the same subject-matter and to differ from each other only with regard to the definition of the subject-matter for which protection is sought and in respect of the terminology used for the features of that subject-matter. The aforementioned claims therefore lack conciseness. Moreover, lack of clarity of the claims as a whole arises, since the plurality of independent claims makes it difficult, if not impossible, to determine the matter for which protection is sought, and places an undue burden on others seeking to establish the extent of the protection.

Hence, claims 1, 9 and 11 do not meet the requirements of Article 6 PCT.

From the INTERNATIONAL SEARCHING AUTHORITY To: NOTIFICATION OF TRANSMITTAL OF BRITISH AEROSPACE plc THE INTERNATIONAL SEARCH REPORT Group I.P. Dept. OR THE DECLARATION Attn. EDIS, RONALD MALCOM MA Lancaster House, P.O. Box 87 (PCT Rule 44.1) Farnborough Aerospace Centre Farnborough, Hampshire, GU14 6YU UNITED KINGDOM Date of (day/month/year) 16/05/2000 Applicant's or agent's file reference FOR FURTHER ACTION See paragraphs 1 and 4 below XA1003 International application No. International filing date (day/month/year) 02/02/2000 PCT/GB 00/00286 Applicant BRITISH AEROSPACE PUBLIC LIMITED COMPANY et al. 1. X The applicant is hereby notified that the International Search Report has been established and is transmitted herewith. Filling of amendments and statement under Article 19: The applicant is entitled, if he so wishes, to amend the claims of the International Application (see Rule 46): The time limit for filing such amendments is normally 2 months from the date of transmittal of the International Search Report; however, for more details, see the notes on the accompanying sheet. International Bureau of WIPO Where? Directly to the 34, chemin des Colombettes 1211 Geneva 20, Switzerland Fascimile No.: (41-22) 740.14.35 For more detailed instructions, see the notes on the accompanying sheet. The applicant is hereby notified that no International Search Report will be established and that the declaration under Article 17(2)(a) to that effect is transmitted herewith. With regard to the protest against payment of (an) additional fee(s) under Rule 40.2, the applicant is notified that: the protest together with the decision thereon has been transmitted to the International Bureau together with the applicant's request to forward the texts of both the protest and the decision thereon to the designated Offices. no decision has been made yet on the protest; the applicant will be notified as soon as a decision is made. Further action(s): The applicant is reminded of the following: Shortly after 18 months from the priority date, the international application will be published by the International Bureau. If the applicant wishes to avoid or postpone publication, a notice of withdrawal of the international application, or of the priority claim, must reach the International Bureau as provided in Rules 90bis.1 and 90bis.3, respectively, before the completion of the technical preparations for international publication. Within 19 months from the priority date, a demand for international preliminary examination must be filed if the applicant wishes to postpone the entry into the national phase until 30 months from the priority date (in some Offices even later). Within 20 months from the priority date, the applicant must perform the prescribed acts for entry into the national phase before all designated Offices which have not been elected in the demand or in a later election within 19 months from the priority date or could not be elected because they are not bound by Chapter II. Name and mailing address of the International Searching Authority Authorized officer

Sandrine Polenzani



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NOTES TO FORM PCT/ISA/220

These Notes are intended to give the basic instructions concerning the filing of amendments under article 19. The Notes are based on the requirements of the Patent Cooperation Treaty, the Regulations and the Administrative Instructions under that Treaty. In case of discrepancy between these Notes and those requirements, the latter are applicable. For more detailed information, see also the PCT Applicant's Guide, a publication of WIPO.

In these Notes, "Article", "Rule", and "Section" refer to the provisions of the PCT, the PCT Regulations and the PCT Administrative Instructions respectively.

INSTRUCTIONS CONCERNING AMENDMENTS UNDER ARTICLE 19

The applicant has, after having received the international search report, one opportunity to amend the claims of the international application. It should however be emphasized that, since all parts of the international application (claims, description and drawings) may be amended during the international preliminary examination procedure, there is usually no need to file amendments of the claims under Article 19 except where, e.g. the applicant wants the latter to be published for the purposes of provisional protection or has another reason for amending the claims before international plucication. Furthermore, it should be emphasized that provisional protection is available in some States only.

What parts of the international application may be amended?

Under Article 19, only the claims may be amended.

During the international phase, the claims may also be amended (or further amended) under Article 34 before the International Preliminary Examining Authority. The description and drawings may only be amended under Article 34 before the International Examining Authority.

Upon entry into the national phase, all parts of the international application may be amended under Article 28 or, where applicable, Article 41.

When?

Within 2 months from the date of transmittal of the international search report or 16 months from the priority date, whichever time limit expires later. It should be noted, however, that the amendments will be considered as having been received on time if they are received by the International Bureau after the expiration of the applicable time limit but before the completion of the technical preparations for international publication (Rule 46.1).

Where not to file the amendments?

The amendments may only be filed with the International Bureau and not with the receiving Office or the International Searching Authority (Rule 46.2).

Where a demand for international preliminary examination has been its filed, see below.

How?

Either by cancelling one or more entire claims, by adding one or more new claims or by amending the text of one or more of the claims as filed.

A replacement sheet must be submitted for each sheet of the claims which, on account of an amendment or amendments, differs from the sheet originally filed.

All the claims appearing on a replacement sheet must be numbered in Arabic numerals. Where a claim is cancelled, no renumbering of the other claims is required. In all cases where claims are renumbered, they must be renumbered consecutively (Administrative Instructions, Section 205(b)).

The amendments must be made in the language in which the international application is to be published.

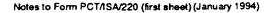
What documents must/may accompany the amendments?

Letter (Section 205(b)):

The amendments must be submitted with a letter.

The letter will not be published with the international application and the amended claims. It should not be confused with the "Statement under Article 19(1)" (see below, under "Statement under Article 19(1)").

The letter must be in English or French, at the choice of the applicant. However, if the language of the international application is English, the letter must be in English; if the language of the international application is French, the letter must be in French.



The letter must indicate the differences between the claims as filed and the claims as amended. It must, in particular, indicate, in connection with each claim appearing in the international application (it being understood that identical indications concerning several claims may be grouped), whether

- (i) the claim is unchanged;
- (ii) the claim is cancelled;
- (iii) the claim is new;
- (iv) the claim replaces one or more claims as filed;
- (v) the claim is the result of the division of a claim as filed.

The following examples illustrate the manner in which amendments must be explained in the accompanying letter:

- [Where originally there were 48 claims and after amendment of some claims there are 51]:
 "Claims 1 to 29, 31, 32, 34, 35, 37 to 48 replaced by amended claims bearing the same numbers;
 claims 30, 33 and 36 unchanged; new claims 49 to 51 added."
- [Where originally there were 15 claims and after amendment of all claims there are 11]: "Claims 1 to 15 replaced by amended claims 1 to 11."
- 3. [Where originally there were 14 claims and the amendments consist in cancelling some claims and in adding new claims]: "Claims 1 to 6 and 14 unchanged; claims 7 to 13 cancelled; new claims 15, 16 and 17 added." or "Claims 7 to 13 cancelled; new claims 15, 16 and 17 added; all other claims unchanged."
- 4. [Where various kinds of amendments are made]: "Claims 1-10 unchanged; claims 11 to 13, 18 and 19 cancelled; claims 14, 15 and 16 reptaced by amended claim 14; claim 17 subdivided into amended claims 15, 16 and 17; new claims 20 and 21 added."

"Statement under article 19(1)" (Rule 46.4)

The amendments may be accompanied by a statement explaining the amendments and indicating any impact that such amendments might have on the description and the drawings (which cannot be amended under Article 19(1)).

The statement will be published with the international application and the amended claims.

It must be in the language in which the international appplication is to be published.

It must be brief, not exceeding 500 words if in English or if translated into English.

It should not be confused with and does not replace the letter indicating the differences between the claims as filed and as amended. It must be filed on a separate sheet and must be identified as such by a heading, preferably by using the words "Statement under Article 19(1)."

It may not contain any disparaging comments on the international search report or the relevance of citations contained in that report. Reference to citations, relevant to a given claim, contained in the international search report may be made only in connection with an amendment of that claim.

Consequence if a demand for international preliminary examination has already been filed

If, at the time of filing any amendments under Article 19, a demand for international preliminary examination has already been submitted, the applicant must preferably, at the same time of filing the amendments with the International Bureau, also file a copy of such amendments with the International Preliminary Examining Authority (see Rule 62.2(a), first sentence).

Consequence with regard to translation of the international application for entry into the national phase

The applicant's attention is drawn to the fact that, where upon entry into the national phase, a translation of the claims as amended under Article 19 may have to be furnished to the designated/elected Offices, instead of, or in addition to, the translation of the claims as filed.

For further details on the requirements of each designated/elected Office, see Volume II of the PCT Applicant's Guide.







INTERNATIONAL SEARCH REPORT

(PCT Article 18 and Rules 43 and 44)

	(PCT Afficie To and nules 45 and 44)	
Applicant's or agent's file reference XA1003	FOR FURTHER See Notification of (Form PCT/ISA/2	f Transmittal of International Search Report 20) as well as, where applicable, item 5 below.
International application No.	International filing date (day/month/year)	(Earliest) Priority Date (day/month/year)
PCT/GB 00/00286	02/02/2000	08/02/1999
Applicant		
BRITISH AEROSPACE PUBLIC	LIMITED COMPANY et al.	
This International Search Report has been according to Article 18. A copy is being tra	n prepared by this International Searching Aut ansmitted to the International Bureau.	nority and is transmitted to the applicant
This International Search Report consists [X] It is also accompanied by	of a total of sheets. a copy of each prior art document cited in this	report.
Basis of the report		
With regard to the language, the language in which it was filed, unl	international search was carried out on the baress otherwise indicated under this item.	sis of the international application in the
the international search w Authority (Rule 23.1(b)).	as carried out on the basis of a translation of t	he international application furnished to this
b. With regard to any nucleotide an was carried out on the basis of the	id/or amino acid sequence disclosed in the in	nternational application, the international search
l <u>—</u>	onal application in written form.	
filed together with the inte	ernational application in computer readable for	n.
	this Authority in written form.	
furnished subsequently to	this Authority in computer readble form.	
the statement that the sul international application a	osequently furnished written sequence listing one is filed has been furnished.	loes not go beyond the disclosure in the
the statement that the info furnished	ormation recorded in computer readable form i	s identical to the written sequence listing has been
2. Certain claims were fou	nd unsearchable (See Box I).	
3. Unity of invention is lac		,
"		
4. With regard to the title,		
the text is approved as su		
	shed by this Authority to read as follows: OSITES AND METHOD OF MAKING	SAME
5. With regard to the abstract,		
the text has been establis	ubmitted by the applicant. shed, according to Rule 38.2(b), by this Author e date of mailing of this international search re	ity as it appears in Box III. The applicant may, port, submit comments to this Authority.
6. The figure of the drawings to be pub		3
X as suggested by the app		None of the figures.
because the applicant fai		
. —	r characterizes the invention.	





	INTERNATIONAL SEARCH REPORT	<u></u>
	INTERNATIONAL SEARCH REPORT	International Application No
•		PCT/GB 00/00286
A. CLASSI IPC 7	FICATION OF SUBJECT MATTER B29C70/52	
According to	o International Patent Classification (IPC) or to both national classification and IPC	
B. FIELDS	SEARCHED	
Minimum do IPC 7	ocumentation searched (classification system followed by classification symbols) B29C	
Documenta	tion searched other than minimum documentation to the extent that such documents are i	included in the fields searched
Electronic d	ata base consulted during the international search (name of data base and, where pract	ical, search terms used)
		•
		·
C. DOCUM	ENTS CONSIDERED TO BE RELEVANT	
Category °	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 5 439 215 A (RATCHFORD DAVID) 8 August 1995 (1995-08-08) column 4, line 33 - line 36	1,6,10
Α	US 4 605 254 A (CARMIEN JOSEPH A) 12 August 1986 (1986-08-12) column 5, line 56 - line 59	1-13
	Cordina 5, True 50 - True 55	
	Column 5, Time 30 - Time 39	
	Column 5, Time 30 Time 39	
	Column 5, Time 30 Time 39	





- Special categories of cited documents:
- "A" document defining the general state of the art which is not considered to be of particular relevance
- earlier document but published on or after the international filing date
- document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- "O" document referring to an oral disclosure, use, exhibition or other means
- document published prior to the international filing date but later than the priority date claimed
- "T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
- "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
- "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other, such document ments, such combination being obvious to a person skilled in the art.
- *&* document member of the same patent family

Date of mailing of the international search report Date of the actual completion of the international search 16/05/2000 8 May 2000 Authorized officer Name and mailing address of the ISA

European Patent Office, P.B. 5818 Patentlaan 2

NL - 2280 HV Rijswijk Tel. (+31-70) 340-2040, Tx. 31 651 epo nl, Fax: (+31-70) 340-3016

Van Wallene, A



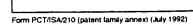
INTERNATIONAL SEARCH REPORT

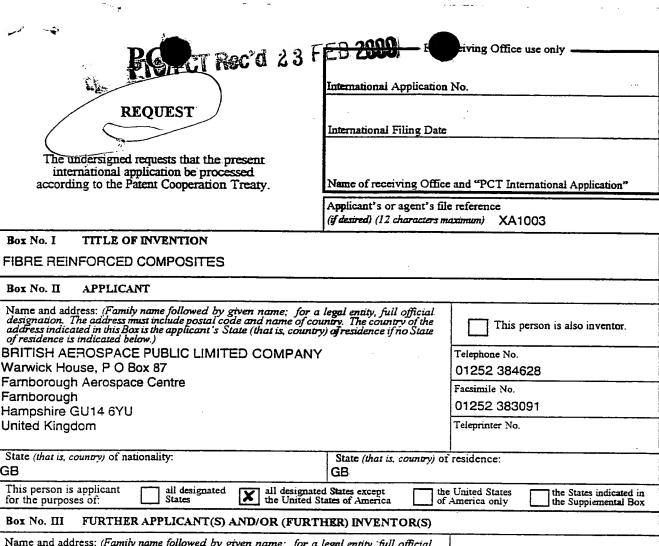
Information on patent family members



International Application No PCT/GB 00/00286

Patent document cited in search report	Publication date		atent family member(s)	Publication date
US 5439215 A	08-08-1995	CA	2132567 A	25-07-1995
US 4605254 A	12-08-1986	US	4570988 A	18-02-1986





This person is applicant for the purposes of: Box No. III Name and address: (Family name followed by given name; for a legal entity, full official designation. The address must include postal code and name of country. The country of the address indicated in this Box is the applicant's State (that is, country) of residence if no State of residence is indicated below.) This person is: applicant only GRAY, lan Lindsay **BAE SYSTEMS** applicant and inventor Building 07C, New Filton House Filton inventor only (If this check-box Bristol, Avon is marked, do not fill in below.) BS99 7AR, United Kingdom

This person is applicant all designated all designated States except the United States of America the United States the States indicated in for the purposes of: of America only the Supplemental Box Further applicants and/or (further) inventors are indicated on a continuation sheet. Box No. IV AGENT OR COMMON REPRESENTATIVE; OR ADDRESS FOR CORRESPONDENCE The person identified below is hereby/has been appointed to act on behalf 🗶 agent common representative of the applicant(s) before the competent International Authorities as: Name and address: (Family name followed by given name; for a legal entity, full official designation. The address must include postal code and name of country.) Telephone No. 01252 383430

GB

State (that is, country) of residence:

EDIS, Ronald Malcolm British Aerospace PLC Group IP Department

Farnborough Aerospace Centre

State (that is, country) of nationality:

Lancaster House, P O Box 87

GB

Farnborough, Hampshire GU14 6YU, United Kingdom

Address for correspondence: Mark this check-box where no agent or common representative is/has been appointed and the space above is used instead to indicate a special address to which correspondence should be sent.

Facsimile No.

Teleprinter No.

01252 383091

B	ox N	o.V DESIGNATI F STATES					
The following designations are neceby made under Rule 4.9(a) (mark the applicable check-boxes; at least one must be marked):							
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		AP ARIPO Patent: GH Ghana, GM Gambia, KE Kenya, LS Lesotho, MW Malawi, SD Sudan, SL Sierra Leone, SZ Swaziland, TZ United Republic of Tanzania, UG Uganda, ZW Zimbabwe, and any other State which is a Contracting State of the Harare Protocol and of the PCT					
Z] EA	A Eurasian Patent: AM Armenia, AZ Azerbaijan, BY Belarus, KG Kyrgyzstan, KZ Kazakhstan, MD Republic of Moldova, RU Russian Federation, TJ Tajikistan, TM Turkmenistan, and any other State which is a Contracting State of the Eurasian Patent Convention and of the PCT					
×	_	European Patent: AT Austria, BE Belgium, CH and LI Switzerland and Liechtenstein, CY Cyprus, DE Germany, DK Denmark, ES Spain, FI Finland, FR France, GB United Kingdom, GR Greece; IE Ireland, IT Italy, LU Luxembourg, MC Monaco, NL Netherlands, PT Portugal, SE Sweden, and any other State which is a Contracting State of the European Patent Convention and of the PCT					
		A OAPI Patent: BF Burkina Faso, BJ Benin, CF Central African Republic, CG Congo, CI Côte d'Ivoire, CM Cameroon, GA Gabon, GN Guinea, GW Guinea-Bissau, ML Mali, MR Mauritania, NE Niger, SN Senegal, TD Chad, TG Togo, and any specify on dotted line) 1. Patent (if other kind of protection or treatment desired.					
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X	HR	Croatia	_	TT	Turkey		
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		Republic of Korea	Che	eck-b	oxes reserved for designating States which have party to the PCT after issuance of this sheet:		
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Pre	cauti	onary Designation Statement: In addition to the designation	tion:	s mad	e above, the applicant also makes under Rule 4.9(b) all other		
	ıgnanı	ons which would be permitted under the PCT except any scope of this statement. The applicant declares that the	desi	gnatic	on(s) indicated in the Supplemental Day as being such and a		

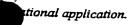
designations which would be permitted under the PCT except any designations (s) indicated in the Supplemental Box as being excluded from the scope of this statement. The applicant declares that those additional designations are subject to confirmation and that any designation which is not confirmed before the expiration of 15 months from the priority date is to be regarded as withdrawn by the applicant at the expiration of that time limit. (Confirmation (including fees) must reach the receiving Office within the 15-month time limit.)

Sheet No. 5

B x No. VI PRIORITY C	LAIM		Further priority claims are indicated in the Supplemental Box.			
Filing date		What the application is:				
of earlier application (day/month/year)	or afficr application	n natio	onal application:	regional application:*	international application:	
			country	regional Office	receiving Office	
item (1) 08/02/1999	9902584.3	GB				
item (2)				<u> </u>		
c						
item (3)						
The receiving Office is requested to prepare and transmit to the International Bureau a certified copy of the earlier application(s) (only if the earlier application was filed with the Office which for the purposes of the present international application is the receiving Office) identified above as item(s): (1)						
* Where the earlier application is Convention for the Protection of Is	on ARIPO amplication it	is mandator	to indicate in the S	upplemental Rax at least or	ne country party to the Paris	
Box No. VII INTERNATIO	ONAL SEARCHING	AUTHORI	TY			
Choice of International Searching Authority (ISA) (if two or more International Searching Authorities are competent to carry out the international search, indicate the Authority chosen; the two-letter code may be used): Request to use results of earlier search; reference to that search (if an earlier search has been carried out by or requested from the International Searching Authority): Date (day/month/year) Number Country (or regional Office)						
ISA / EP		26/08/19	999	99302224.3-1253	EP	
Box No. VIII CHECK LIS	T: LANGUAGE OF	FILING				
This international application			cation is accompa	nied by the item(s) mark	red below:	
the following number of shee	rs:	alculation s				
request 3	2. 🗀 sepa	rate signed	power of attorney			
description (excluding sequence listing part) : 4	3. 🗷 copy	of general	power of attorney	, reference number, if ar	ıy:	
claims 2	4. 🔲 state	ment expla	ining lack of signa	ture		
abstract : 1	5. 🔲 prio	rity docume	nt(s) identified in	Box No. VI as item(s):		
drawings : 2	6. ☐ tran	slation of in	ternational applica	tion into (language):		
sequence listing part	7. ☐ sepa	rate indicat	ions concerning de	eposited microorganism	or other biological material	
of description	8. 🔲 nuc	leotide and/	or amino acid sequ	ence listing in computer	readable form	
Total number of sheets : 12	9. 🗷 othe	r (specify):	GB FORM 23/77 I	REQUEST CERTIFIED C	OPY	
Figure of the drawings which should accompany the abstract: 3 Language of filing of the international application: ENGLISH						
Box No. IX SIGNATURE OF APPLICANT OR AGENT						
			y in which the person s	igns (if such capacity is not ob	vious from reading the request).	
Next to each signature, indicate the name of the person signing and the capacity in which the person signs (if such capacity is not obvious from reading the request).						
Ronald Malcolm EDIS		•				
					-	
For receiving Office use only						
1. Date of actual receipt of the purported international application: 2. Drawings:						
3. Corrected date of actual receipt due to later but timely received papers or drawings completing the purported international application:						
4. Date of timely receipt of the required corrections under PCT Article 11(2):						
5. International Searching A (if two or more are comp	authority ISA /		6. Transm until se	nittal of search copy delay arch fee is paid.	yed	
	F	or Internatio	nal Bureau use on	ly		
Date of receipt of the record copy by the International Bureau:						

Form PCT/RO/101 (last sheet) (July 1998; reprint January 2000)

See Notes to the request form



PCT

FEE CALCULATION SHEET

	For receiving	Office use only	
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nternational applic	ation No.		

Annex to the Request	memadonal application 140.					
Applicant's or agent's file reference XA1003	Date stamp of the receiving Office					
Applicant BRITISH AEROSPACE PUBLIC LIMED COMPANY						
CALCULATION OF PRESCRIBED FEES 1. TRANSMITTAL FEE 2. SEARCH FEE International search to be carried out by EP (If two or more International Searching Authorities are competent in relation application, indicate the name of the Authority which is chosen to carry out the in-						
3. INTERNATIONAL FEE Basic Fee The international application contains 12 sheets. first 30 sheets	рі					
remaining sheets additional amount Add amounts entered at b1 and b2 and enter total at B £264.00 B						
Designation Fees The international application contains MAX designations. 8	8.00 D					
Add amounts entered at B and D and enter total at I (Applicants from certain States are entitled to a reduction of 75% of international fee. Where the applicant is (or all applicants are) so entitled total to be entered at I is 25% of the sum of the amounts entered at B and 4. FEE FOR PRIORITY DOCUMENT (if applicable)	£712.00 I I					
5. TOTAL FEES PAYABLE Add amounts entered at T. S. Land P. and enter total in the TOTAL have						
The designation fees are not paid at this time.						
MODE OF PAYMENT authorization to charge bank draft coupons cheque cash other (specify): postal money order revenue stamps						
DEPOSIT ACCOUNT AUTHORIZATION (this mode of payment may not be available at all receiving Offices) The RO/ GB						
Bureau of WIPO to my deposit account.	LMALis					
Deposit Account No. Date (day/month/year)	Signature					
Form PCT/RO/101 (Annex) (January 2000)						